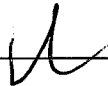
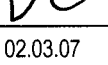


Date: Tuesday, 19/09/2006 7:01:54 AM
 User: Linda Lacelle

Process Sheet











Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28645
 Estimate Number : 11041
 P.O. Number : N/A
 This Issue : 19/09/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 28629
 Written By : 
 Checked & Approved By : 
 Comment : Est C 02.03.07 Now turned in house NG

Drawing Name : BUSHING
 Part Number : D2809
 Drawing Number : D2809 REV A1
 Project Number : N/A
 Drawing Revision : A1
 Material : N/A
 Due Date : 19/09/2006
 Qty: 64 (60) Um: Each


Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0500	6061-T6 Round Bar .500"
 		
Comment: Qty.: 0.1045 f(s)/Unit Total: 6.2685 f(s) 6061-T6 Round Bar .500" Material: 6061-T6 (QQ-A-250-11) rod .500"Ø Batch: 101421 BG 06.09.19		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
 		
Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA204		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE BG for J.L. 06.09.19 64		
4.0	QC8	SECOND CHECK
 		
Comment: SECOND CHECK SA 06.09.19 64		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
 		
Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumple & deburr all sharp edges as per dwg BG 06.09.19 64		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/18/04

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/09/2006 7:01:54 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 28645

Part Number: D2809

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

9.m

06-09-19

(64)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

gloss white

Powder coat _____ per QSI 005 4.3

9.m

06-10-03

(64) P70

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

PC

06-10-03

(64)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 388*

Boe/10/03

(64)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(64)

Comment: FINAL INSPECTION/W/O RELEASE

Boe/10/04

Job Completion



C 206/10/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/10/02	7	permanent chg				U	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

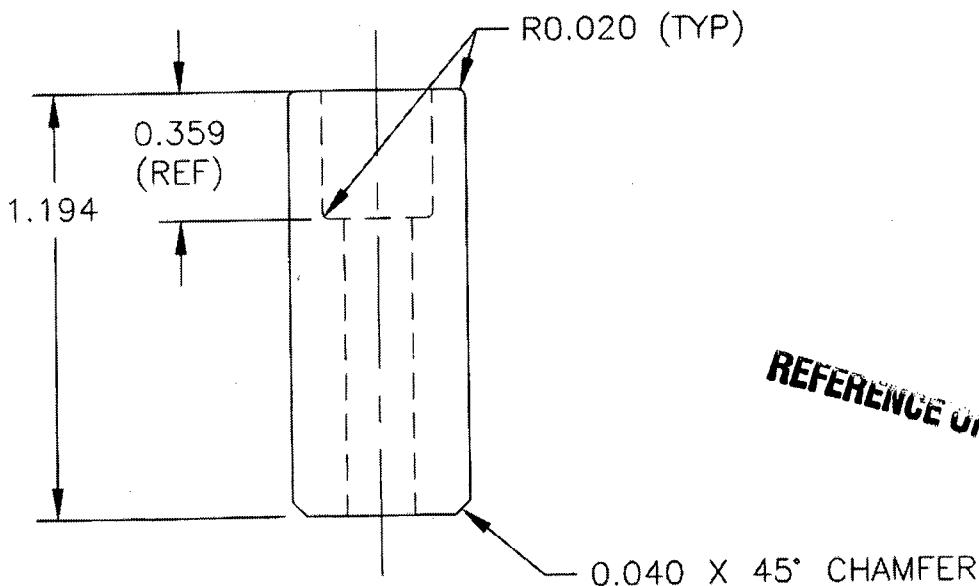
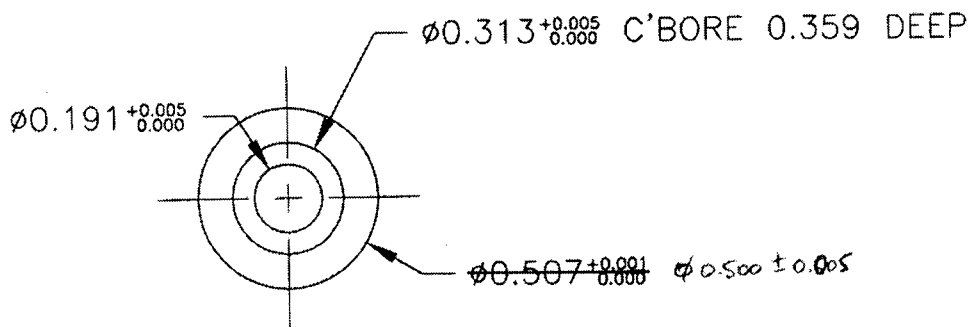
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	01.04.26	ADD POWDER COAT; $\phi 0.500$ WTS $\phi 0.507$	

RELEASED
00.11.13



REFERENCE ONLY

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)

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FOR DART QSI 005 4.3

